

Date: Thursday, 11/09/2008 10:42:01 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	SADDLE, INBOARD, RS, 206		
Job Number	41976			Part Number	D26662		
Estimate Number	10821			Drawing Number	D2666 REV.D		
P.O. Number	:			Project Number	N/A		
This Issue	11/09/2008	S.O. No.	:	Drawing Revision	D		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	MACHINED PARTS	Due Date	10/10/2008		
Previous Run	38752			Qty:	10	Um:	Each
Written By				Comment			
Checked & Approved By	<u>JUL 08.9.04</u>			Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM		

Additional Product

Job Number:

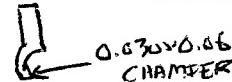


Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection last completed on <u>08/09/26</u> by <u>ML</u> 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2666-2 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/10/03

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 41976		WORK ORDER NON-COMFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			
08.09.29	Z	THERE IS A 0.030" X 0.060" CHAMFER ON THE BOTTOM EDGE QTY (2) 	GP 08.09.29 per QSI QYL	PARTS ACCEPTABLE, NOT IN STRESSED AREA.	9ml 08/09/29	S 08/09/29	GP 08.09.29 per QSI QYL	S 08/09/29	

NOTE: Date & initial all entries

Date: Thursday, 11/09/2008 10:42:01 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 41976

Part Number: D26662

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MJ 08/09/27

(10)

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

DIP 08/09/29

(10)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fd 08/09/30

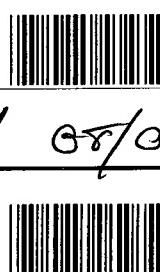
(1e)

7.0 POWDER COATING

POWDER COATING



M 10 91 52



(10x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:00

11:00
09:01

OVEN TEMPERATURE: 320°

320°

FINISH TIME: 11:30

11:30

MJ 08/09/30

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MJ



Comment: INSPECT POWDER COAT

08-09-30

(10)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STYRE

Packaging 1

9/10/08

(10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MJ 08-10-01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-COMFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41970
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.126	.127	.127		
B	0.100	0.140		.110	.112	.112	.112		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.135	.135	.135	.135		
E	0.210	0.230		.217	.221	.220	.220		
F	1.313	1.343		1.322	1.322	1.322	1.322		
G	0.240	0.260		.250	.248	.248	.250		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.134	1.137	1.137	1.138		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.237	.237	.237	.237		
L	0.510	0.515		.512	.512	.512	.512		
M	0.100	0.120		.110	.110	.110	.110		
N	1.565	1.585		1.570	1.571	1.571	1.570		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.500	.500	.500		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.499	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.362	1.361	1.361		
V	0.315	0.322		.321	.321	.321	.321		
W	0.540	0.560		.547	.549	.550	.550		
X	1.674	1.684		1.676	1.678	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>GJF</i>	Audited by:	<i>DTP</i>
Date:	08/09/27	Date:	08/09/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM <i>GJF</i>	<i>GJF</i>

DART AEROSPACE LTD	Work Order:	41974
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.122	.125	.126		
B	0.100	0.140		.112	.112	.113	.112		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.135	.135	.137	.138		
E	0.210	0.230		.219	.221	.221	.221		
F	1.313	1.343		1.322	1.322	1.322	1.322		
G	0.240	0.260		.249	.247	.247	.248		
H	0.615	0.685		.666	.666	.666	.666		
I	1.125	1.145		1.137	1.137	1.136	1.137		
J	0.990	1.010		1.006	1.000	.999	1.000		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.511	.510	.511	.510		
M	0.100	0.120		.110	.112	.112	.110		
N	1.565	1.585		1.570	1.570	1.570	1.570		
O	5.990	6.010		6.006	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.506	.500	.504	.500		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.506	2.506	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.321	.321	.321	.321		
W	0.540	0.560		.550	.550	.550	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	One	Audited by:	DJP
Date:	08/09/29	Date:	08/09/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	41974
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.126				
B	0.100	0.140		.112	.112				
C	2.470	2.510		2.496	2.496				
D	0.100	0.180		.138	.138				
E	0.210	0.230		.221	.221				
F	1.313	1.343		1.322	1.322				
G	0.240	0.260		.249	.248				
H	0.615	0.685		.660	.660				
I	1.125	1.145		1.136	1.136				
J	0.990	1.010		1.000	1.000				
K	0.235	0.240		.238	.238				
L	0.510	0.515		.510	.511				
M	0.100	0.120		.110	.110				
N	1.565	1.585		1.569	1.569				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.490	0.510		.503	.501				
S	0.313	0.318		.318	.318				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.315	0.322		.321	.321				
W	0.540	0.560		.550	.551				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.259	.259				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>cmf</i>	Audited by:	<i>DSR</i>
Date:	08/09/28	Date:	08/09/29

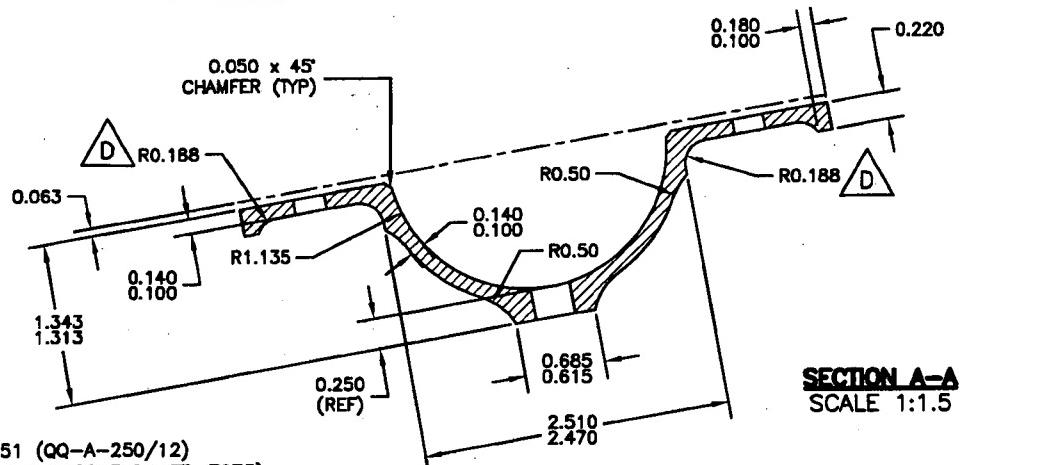
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM <i>cmf</i>	<i>cmf</i>

DART

DESIGN <i>A</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD INSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

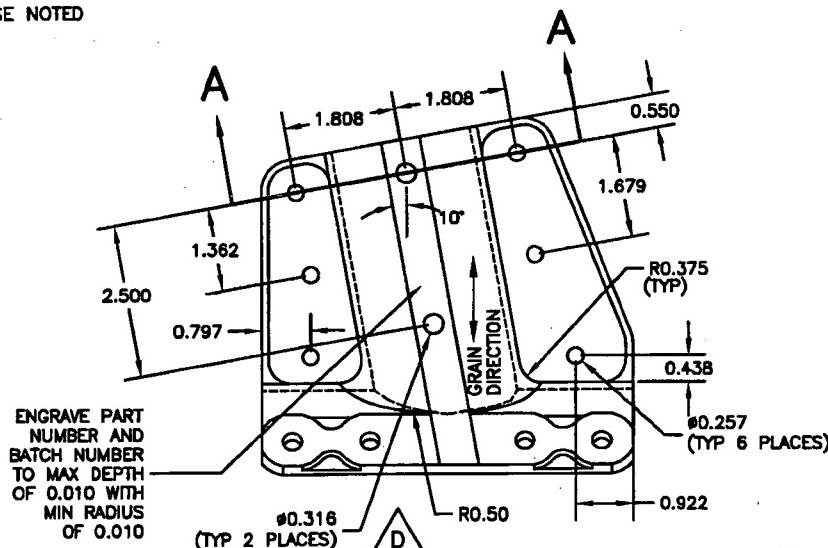
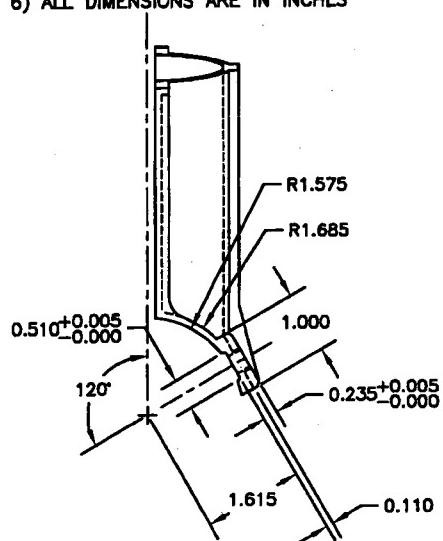
RELEASED

07.02.12 *PH*

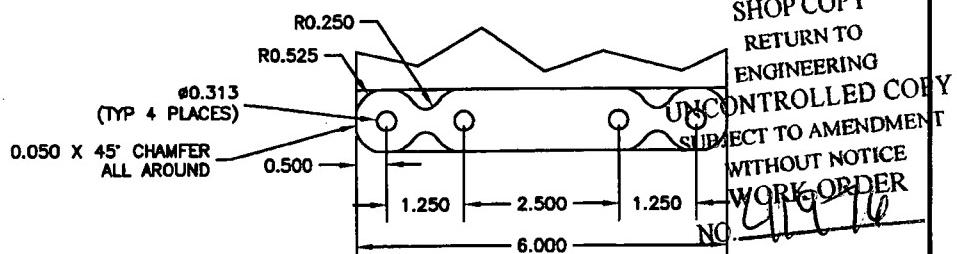


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH



Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.